



Europäisches Patentamt
European Patent Office
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(11) Publication number:

0 519 468 A2

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 92110305.7

(51) Int. Cl.⁵: C03B 37/014

(22) Date of filing: 17.06.92

(30) Priority: 19.06.91 JP 147269/91
27.11.91 JP 312245/91

(43) Date of publication of application:
23.12.92 Bulletin 92/52

(84) Designated Contracting States:
BE DE DK FR GB IT NL SE

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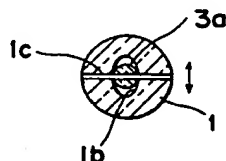
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(54) Apparatus for supporting article in heating furnace.

(57) An apparatus for suspending a glass article to be heat treated in a heating furnace from a quartz rotary shaft (1), so as to support the glass article. A slot (1b) is provided in the apparatus for receiving a cylindrical projection (3a) formed at an upper end of the glass article, which has an elliptical cross section and is formed at a lower end of the rotary shaft (1). Furthermore, a pin hole (1c) for securing the glass article to the rotary shaft (1) is provided which is formed on the rotary shaft (1) along a minor axis of the slot (1b). A clearance between a peripheral surface of the slot (1b) and that of the cylindrical projection (3a) along the minor axis of the slot (1b) is set to not more than 0.2 mm, while a clearance between the peripheral surface of the slot (1b) and that of the cylindrical projection (3a) along a major axis of the slot (1b) is set to not less than 0.4 mm.

Fig. 2



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BACKGROUND OF THE INVENTION

The present invention relates to an apparatus for suspending a starting member from a rotary shaft so as to support the starting member, which is used at the time of manufacture of glass preform suitable for production of an optical fiber.

For production of the optical fiber, VAD (vapor phase axial deposition) method is known. Fig. 4 shows VAD method schematically. In Fig. 4, minute glass particles 4 of SiO_2 formed in oxy-hydrogen flame are deposited on a quartz rod 5 mounted on a distal end of a rotating quartz bar 3 so as to make cylindrical porous preform and the porous preform is sintered so as to produce transparent preform of the optical fiber. The quartz bar 3 and the quartz rod 5 act as the starting member.

Fig. 1 is a longitudinal sectional view showing a connecting portion between the quartz bar 3 and a rotary shaft 1 in a prior art apparatus, while Fig. 3 is a cross-sectional view of the connecting portion in the prior art apparatus. As shown in Figs. 1 and 3, a cylindrical projection 3a is provided at an upper end of the quartz bar 3, while a cylindrical slot 1a for receiving the cylindrical projection 3a is formed at a lower end of the rotary shaft 1. A pin hole 1c further extends through a lower end portion of the rotary shaft 1 across the cylindrical slot 1a. After the cylindrical projection 3a of the quartz bar 3 has been fitted into the cylindrical slot 1a of the rotary shaft 1, the projection 3a is coupled with the rotary shaft 1 by driving a pin 2 into the pin hole 1c of the rotary shaft 1 through the projection 3a. In the prior art apparatus, a clearance between a diameter of the slot 1a and a diameter of the projection 3a is set at about 0.1 mm such that run-out of the glass preform at the time of rotation of the rotary shaft 1 is eliminated.

However, since the prior art apparatus for supporting the glass preform is subjected to thermal deformation due to its long-term use or a pin hole of the projection 3a and the rotary shaft 1 is deformed by weight of the preform, it is impossible to eliminate run-out of the preform.

Meanwhile, if run-out of the preform takes place, heat applied to the porous preform in a furnace becomes nonuniform. As a result, shrinkage speed of the porous preform becomes nonuniform when the porous preform is changed to the glass preform, so that the glass preform is deformed as shown in, for example, Fig. 5. In Fig. 5, the glass preform has not only an effective portion A but a bent ineffective portion B undesirably. This phenomenon is particularly conspicuous in the case where the porous preform is deposited around the quartz rod by outside vapor phase deposition method and is sintered.

SUMMARY OF THE INVENTION

Accordingly, an essential object of the present invention is to provide, with a view to eliminating the above mentioned disadvantages of conventional apparatuses, an apparatus for supporting on a rotary shaft, an article to be heat treated in a heating furnace, e.g., glass preform without incurring run-out of the glass preform.

In order to accomplish this object of the present invention, there is provided an apparatus for suspending from a quartz rotary shaft, a glass article to be heat treated in a heating furnace so as to support the glass article, according to the present invention, the improvement comprises: a slot for receiving a cylindrical projection formed at an upper end of the glass article, which has an elliptical cross section and is formed at a lower end of the rotary shaft; and a pin hole for securing the glass article to the rotary shaft, which is formed on the rotary shaft along a minor axis of the slot; wherein a clearance between a peripheral surface of the slot and that of the cylindrical projection along the minor axis of the slot is set to not more than 0.2 mm, while a clearance between the peripheral surface of the slot and that of the cylindrical projection along a major axis of the slot is set to not less than 0.4 mm.

BRIEF DESCRIPTION OF THE DRAWINGS

This object and features of the present invention will become apparent from the following description taken in conjunction with the preferred embodiments thereof with reference to the accompanying drawings, in which:

Fig. 1 is a schematic longitudinal sectional view of a connecting portion between a quartz bar and a rotary shaft in a prior art apparatus for supporting glass preform (already referred to);

Fig. 2 is a cross-sectional view of a connecting portion between a quartz bar and a rotary shaft in an apparatus for supporting glass preform, according to a first embodiment of the present invention;

Fig. 3 is a cross-sectional view of the connecting portion of the prior art apparatus of Fig. 1 (already referred to);

Fig. 4 is a schematic view explanatory of VAD method (already referred to);

Fig. 5 is a view showing bending of the glass preform in the prior art apparatus of Fig. 1;

Figs. 6a to 6d are cross-sectional views showing clearance between a projection of the quartz bar and a slot of the rotary shaft in the apparatus of Fig. 2 and comparative examples;

Fig. 7 is a perspective view of a rotary shaft employed in an apparatus according to a second embodiment of the present invention;

Fig. 8 is a cross-sectional view of the apparatus of Fig. 7; and

Fig. 9 is a perspective view of a platelike projection of a quartz bar which is one of the examples employed in the apparatus of Fig. 7.

Before the description of the present invention proceeds, it is to be noted that like parts are designated by like reference numerals throughout several views of the accompanying drawings.

DETAILED DESCRIPTION OF THE INVENTION

The present inventors studied causes of run-out of glass preform in a known heating furnace. The study revealed that the known heating furnace has a structure shown in Fig. 1 in which a gravitational force of the glass preform prevents the glass preform to move in an axial direction of a pin 2 for fixing a quartz bar 3 to a rotary shaft 1 but the glass preform is readily moved in a direction perpendicular to the axial direction of the pin 2 so as to be rotated about the pin 2. The quartz bar 3 and a quartz rod 5 attached to the quartz bar 3 acts as a starting member. Therefore, if clearance between a projection of the quartz bar 3 and a slot of the rotary shaft 1 is small, the projection strikes a peripheral surface of the slot repeatedly, thereby resulting in run-out of the glass preform.

Then, the present inventors examined run-out of the glass preform by changing clearance between the projection and the slot variously as shown in Table 1 below.

Table 1

Type	Dia. of projection (3a) (mm)	Clearance (mm)		Cross section	Run-out
		a	b		
I	18.0	0.25	0.25	Fig. 6a	Run-out occurs with clattering sounds.
II	18.0	0.1	0.1	Fig. 6b	Run-out occurs more intensely with clattering sounds.
III	18.0	0.2	0.4	Fig. 6c	No run-out occurs.
IV	14.0	2.2	2.4	Fig. 6d	Large run-out occurs.

In Table 1 above, character a denotes an axial direction of the pin 2, while character b denotes a direction perpendicular to the axial direction of the pin 2. Initially, types I and II in which a cylindrical projection 3a is fitted into a cylindrical slot 1a as shown in Fig. 3 are compared. In the type I having a clearance of 0.25 mm, run-out occurs with clattering sounds. Meanwhile, in the type II having a clearance of 0.1 mm, amount of run-out is larger than that of the type I.

On the other hand, in the case where the cylindrical projection 3a is fitted into a slot 1b having an elliptical cross section and a pin hole 1c extends along a minor axis of the elliptical slot 1b as shown in Fig. 2, large run-out occurs in a type IV having a clearance of 2.2 mm in the axial direction of the pin 2 because it is difficult to fix the cylindrical projection 3a at the center of the elliptical slot 1b in the type IV. However, in a type III in which a clearance in the axial direction of the pin 2 is set to 0.2 mm and a clearance in the direction perpendicular to the axial direction of the pin 2 is set to 0.4 mm, the cylindrical projection can be fixed at the center of the elliptical slot 1b and no obstacle is present in the direction perpendicular to the axial direction of the pin 2, so that substantially no run-out occurs.

Based on the above results, the present invention employs the cylindrical projection 3a and the elliptical slot 1b and sets clearances in the axial direction of the pin 2 and in the direction perpendicular to the axial direction of the pin 2 to not more than 0.2 mm and not less than 0.4 mm, respectively such that not only run-out of the glass preform at the time of its rotation is eliminated but bending of the sintered glass preform is prevented.

Therefore, in an apparatus for supporting a glass article, according to a first embodiment of the present invention, the single pin hole 1c is formed in the direction of the minor axis of the elliptical slot 1b so as to

not only eliminate run-out of the glass preform but prevent bending of the glass preform. This is because if the clearance in the direction perpendicular to the axial direction of the pin hole is small in contrast with the present invention, the projection moves in the direction perpendicular to the axial direction of the pin hole during the rotation and comes into contact with the slot, thus resulting in run-out and bending of the glass preform.

Figs. 7 to 9 show an apparatus for supporting a glass article, according to a second embodiment of the present invention. In Figs. 7 and 8, an elongated slot 1d is formed on the bottom end of the rotary shaft 1 so as to open at opposite sides of the rotary shaft 1. Meanwhile, the quartz bar 3 is formed, on its top end, with the cylindrical projection 3a as shown in Fig. 2 or a platelike projection 3b as shown in Fig. 9. Furthermore, the pin hole 1c extends in a direction perpendicular to the longitudinal direction of the elongated slot 1d. By the above described arrangement of the apparatus, run-out of the glass preform can be eliminated in the same manner as in the apparatus of Fig. 2.

Hereinbelow, concrete examples of the apparatus of the present invention are described together with comparative examples.

[Example 1]

This example 1 corresponds to the type III of Table 1. A quartz rod of 15 mm in diameter is attached to a lower end of a quartz starting member of 18.5 mm in diameter and a cylindrical projection of 18.0 mm in diameter is provided at an upper end of the starting member. Then, porous preform is deposited around the quartz rod to a thickness of 140 mm over a distance of 500 mm. The cylindrical projection of the starting member is fitted into an elliptical slot formed at a lower end of a quartz rotary shaft and then, the starting member is secured to the rotary shaft by a pin. The elliptical slot has a major diameter of 18.8 mm and a minor diameter of 18.4 mm. Then, the porous preform is inserted into a heating furnace heated to 1600 °C and is changed to transparent glass in atmosphere of 100 % of helium. As a result, the sintered material is not subjected to bending at all and excellent preform can be obtained over a distance of 400 mm.

[Example 2]

This example 2 corresponds to the apparatus of Fig. 7. A quartz rod of 15 mm in diameter is fixed to a lower end of a quartz starting member of 18.5 mm in diameter and a cylindrical projection of 18.0 mm in diameter is formed at an upper end of the starting member. Subsequently, porous preform is deposited around the quartz rod to a thickness of 140 mm over a distance of 500 mm. The cylindrical projection of the starting member is fitted into an elongated slot formed at a lower end of a quartz rotary shaft and then, the starting member is fixed to the rotary shaft by a pin. The elongated slot has a width of 18.2 mm.

Thereafter, when the porous preform is inserted into a heating furnace heated to 1600 °C and is changed to transparent glass in atmosphere of 100 % of helium, the sintered material is not bent at all and excellent preform can be obtained over a distance of 400 mm.

(Comparative example 1)

This comparative example 1 corresponds to the type 1 of Table 1. A quartz rod of 15 mm in diameter is fixed to a lower end of a quartz starting member of 18.5 mm in diameter. A cylindrical projection of 18.0 mm in diameter is provided at an upper end of the starting member. Meanwhile, a circular slot of 18.5 mm in diameter is formed at a lower end of a quartz rotary shaft such that a clearance of 0.25 mm is defined between the cylindrical projection and the circular slot. After the cylindrical projection has been fitted into the circular slot, the starting member is secured to the rotary shaft by a pin. Subsequently, transparent glass is produced under the same conditions as those of the examples 1 and 2. As a result, bending of the sintered material is produced and thus, the bent portion of 50 mm in length is required to be discarded.

(Comparative example 2)

This comparative example 2 corresponds to the type II of Table 1, in which clearance between the cylindrical projection and the circular slot is set to 0.1 mm in the above comparative example 1. When the sintered material is produced in the same manner as in the comparative example 1, a lower portion of 90 mm in length should be discarded from the sintered material.

As is clear from the foregoing description, since run-out of the glass preform can be prevented by the above described arrangement of the apparatus of the present invention and thus, excellent sintered material

free from bending can be obtained.

Claims

- 5 1. In an apparatus for suspending from a quartz rotary shaft, a glass article to be heat treated in a heating furnace so as to support the glass article, the improvement comprising:
a slot for receiving a cylindrical projection formed at an upper end of the glass article, which has an elliptical cross section and is formed at a lower end of the rotary shaft; and
a pin hole for securing the glass article to the rotary shaft, which is formed on the rotary shaft along
10 a minor axis of the slot;
wherein a clearance between a peripheral surface of the slot and that of the cylindrical projection along the minor axis of the slot is set to not more than 0.2 mm, while a clearance between the peripheral surface of the slot and that of the cylindrical projection along a major axis of the slot is set to not less than 0.4 mm.
- 15 2. In an apparatus for suspending from a quartz rotary shaft, a glass article to be heat treated in a heating furnace so as to support the glass article, the improvement comprising:
an elongated slot for receiving a cylindrical projection or a platelike projection formed at an upper end of the glass article, which is formed at a lower end of the rotary shaft; and
20 a pin hole for securing the glass article to the rotary shaft, which is formed on the rotary shaft in a direction perpendicular to a longitudinal direction of the elongated slot.
3. An apparatus as claimed in Claim 2, wherein a clearance between each of opposite faces of the elongated slot and a peripheral surface of the cylindrical projection or a corresponding one of opposite
25 faces of the platelike projection of the glass article is set to be not more than 0.2 mm.

Fig. 1 PRIOR ART

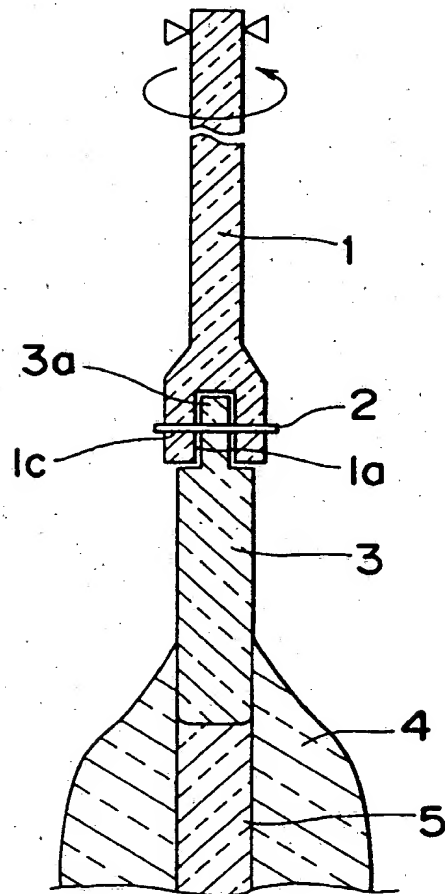


Fig. 2

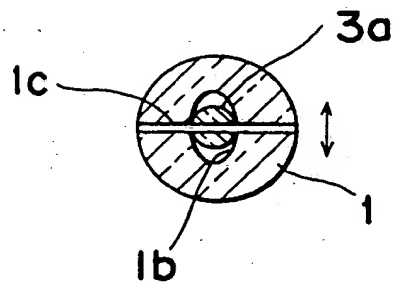


Fig. 3 PRIOR ART

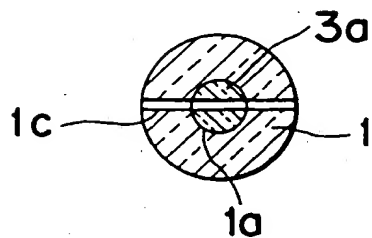


Fig. 4 PRIOR ART

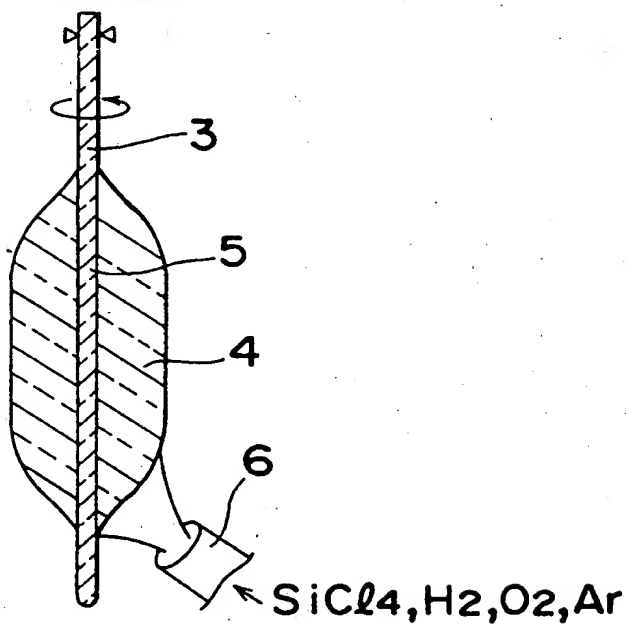


Fig. 5 PRIOR ART

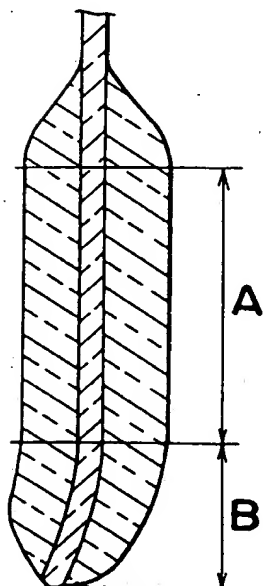


Fig. 6a
PRIOR
ART

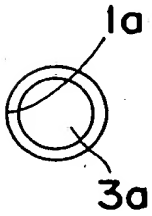


Fig. 6b
PRIOR
ART

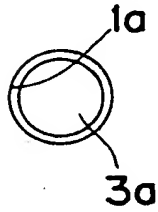


Fig. 6c

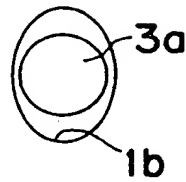


Fig. 6d

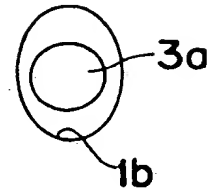


Fig. 7

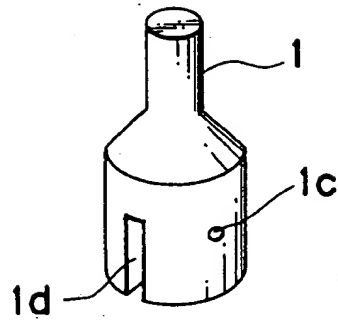


Fig. 8

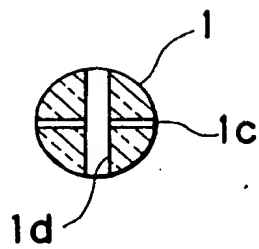
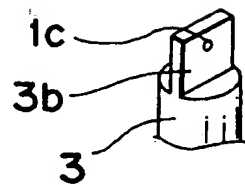


Fig. 9





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European Patent Office
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(11) Publication number:

0 519 468 A3

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 92110305.7

(51) Int. Cl.⁵: **C03B 37/014**

(22) Date of filing: 17.06.92

(30) Priority: 19.06.91 JP 147269/91
27.11.91 JP 312245/91

(43) Date of publication of application:
23.12.92 Bulletin 92/52

(84) Designated Contracting States:
BE DE DK FR GB IT NL SE

(66) Date of deferred publication of the search report:
03.02.93 Bulletin 93/05

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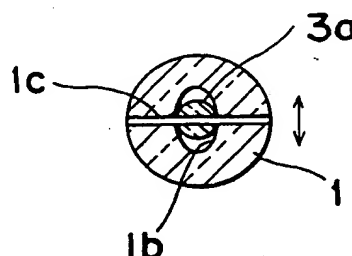
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(54) **Apparatus for supporting article in heating furnace.**

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axis of the slot (1b) is set to not less than 0.4 mm.

Fig. 2



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EUROPEAN SEARCH REPORT

Application Number

EP 92 11 0305

DOCUMENTS CONSIDERED TO BE RELEVANT

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
P,X	PATENT ABSTRACTS OF JAPAN vol. 16, no. 29 (C-904)24 January 1992 & JP-A-03 242 339 (FUJIKURA LTD.) 29 October 1991 * abstract; figure 12 * -----	2	C03B37/014
A	PATENT ABSTRACTS OF JAPAN vol. 15, no. 128 (C-818)28 March 1991 & JP-A-03 012 336 (FUJIKURA LTD.) 21 January 1991 * abstract; figures 1-3 * -----	1,2	
A	PATENT ABSTRACTS OF JAPAN vol. 14, no. 417 (C-756)10 September 1990 & JP-A-02 160 636 (SUMITOMO ELECTRIC IND.LTD.) 20 June 1990 * abstract; figures 1,3 * -----	1,2	
A	PATENT ABSTRACTS OF JAPAN vol. 12, no. 139 (C-491)27 April 1988 & JP-A-62 256 735 (HITACHI CABLE LTD.) 9 November 1987 * abstract; figures 1,2 * -----	1,2	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			C03B
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	24 NOVEMBER 1992	STROUD J.G.	
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document	
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EPO FORM 150 (1.1) (P0001)